

Work Order ID 50043

July 6, 2009 1:28:12 PM



Page 1

Item ID: D3053-042

Accept



Setup Start



Revision ID: B

Stop



Item Name: 212 Basket Base Assembly

Start Date: 07/06/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/10/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3053	Rev B

100



Large Fab

0.00

*(P.D.) →
SAO 09-07-07*

Large Fab

Memo

0.00

1-Cut 5 D2235-3 FROM D3166-1 using DT8365. 12-Drill holes in three D2235-3 ribs as per dwg D3053 using DT8995

110



Large Fab

0.00

Large Fab

Memo

0.00

1-Remove all markings from material 12-Weld as per Dwg D3053 using Welding Table and corner Jig Deburr as required

PD 09-07-10

120



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

PPL 09-07-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3053-042 PAR #: N/A Fault Category: Pass - Lge fab NCR: Yes No DQA: A Date: 09-07-10
 Resolution: Re-work Disposition: Re-work QA: N/C Closed: Date: 05-08-17

NCR: 50043		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-07-09	100 110	The Tx D3053- was drilled incorrectly. See. between C & D was drilled by mistake. Should have been. C-C. A.C: Human error / L.O.A to detail.	QSIUZ	- fill the affected holes on the -3 rib with weld per QSIU004. Grind flush & ensure there is no foreign objects in the rib or basket. Drill C-C per drawing & remove all debris.	09-07-09	S 02/02/10	QSIUZ	05-07-10

NOTE: Date & initial all entries

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Required Date: 07/10/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
-------------	-----------	-----------	------------	------------	---------------	-------------

130



QC6- Inspect dimensions to drawing

0.00

27
Soil test 16

QC

Quality Control

140



DOCUMENT CONTROL

0.00

DC

Document Control

Memo

0.00

Take Traveller D205-541-043 to KP

150



White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

Powdercoat

Powder Coating

Memo

0.00

START TIME: 9:26AM OVEN TEMPERATURE:

FINISH TIME: 9:50AM

400F

M112148

09-07-10

PRESSURE WASH

09-07-10

BK

JK

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Item ID: D3053-042

Accept



Setup Start



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Stop



Item Name: 212 Basket Base Assembly

Start Date: 07/06/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/10/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

09-07-10

①

BR

170



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Picklist Print

Page 1

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Work Order ID: 50043



Parent Item: D3053-042RevB



Parent Item Name: 212 Basket Base Assembly

Start Date: 07/06/2009

Required Date: 07/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2232-3RevC		Manufactured	No			110	Each	15.0000	2.0000			

Basket Hinge

Warehouse

Location

Main Warehouse

ST

Loc Qty

Loc Code

15

47263

48443

1
1

PD 09.07.08

D2327-3RevD



Manufactured No

110 Each 78.0000 2.0000



Spacer Bushing

Warehouse

Location

Premier

Mezz

Loc Qty

Loc Code

78

44274

44365

2
2

PD 09.07.09

D2581RevA1



Manufactured No

110 Each 35.0000 2.0000



Mounting Bracket

Warehouse

Location

Main Warehouse

ST

Loc Qty

Loc Code

35

46086

48428

2
2

PD 09.07.09

Picklist Print

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Work Order ID: 50043



Parent Item: D3053-042RevB



Parent Item Name: 212 Basket Base Assembly

Start Date: 07/06/2009

Required Date: 07/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3166-1RevA1		Manufactured	No			110	Each	0.0000	5.0000		B49491 → 1	
Basket Hoop											B49573 → 4	PD 09-07-07
M304EX0.75-16F		Purchased	No			100	sf	886.5700	50.5263			
Expanded Metal Flat SS												

<u>Warehouse</u>	<u>Loc Oty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

MAT	886.57	
108152	90	
110134	6.7	
110292	14.4	
110629	14.41	
110861	21.18	
110992	0.58	
111444	17.79	
111630	35.15	
111956	46.36	
112147	640	

- 10.00
- 40.5263 SAO 09-07-08

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Shop Packet Print

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Picklist Print

Page 3

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Parent Item: D3053-042RevB



Parent Item Name: 212 Basket Base Assembly

Start Date: 07/06/2009

Required Date: 07/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TS0.750W.065		Purchased	No			100	f	680.8900	45.6140			

304 SQ Tube .75x.75x.065W



Warehouse

Location

Main Warehouse

MAT	680.89	
110969	3.29	
111148	15.96	
111331	1.96	
111432	0.44	
111885	25.14	
112051	634.1	

46.6140 SAW 09-07-07

8 7 6 5 4 3 2 1

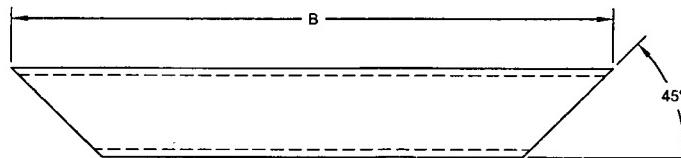
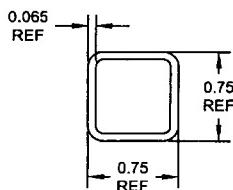
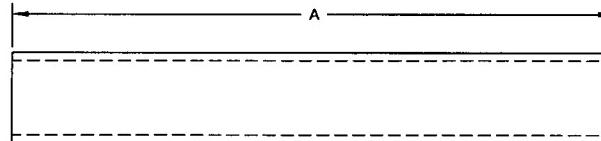
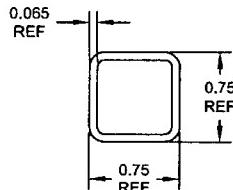
PARTS LIST FOR D3053-041/D3053-042 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3053-1	2	—	96.00	RIB
D3053-3	2	—	25.50	RIB
D3053-5	6	23.73	—	RIB
D3053-7	3	25.31	—	RIB
D3053-9	3	19.48	N/A	RIB
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRACKET
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-3	5	N/A	N/A	RIB

REFERENCE ONLY

MF
09-01-00

RELEASED
09-01-00



B

- NOTES:**
- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
 - 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
 - 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
 - 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 7) IDENTIFICATION: NONE
 - 8) WEIGHT: N/A
 - 9) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
 - 10) WELD PER DART QSI 004

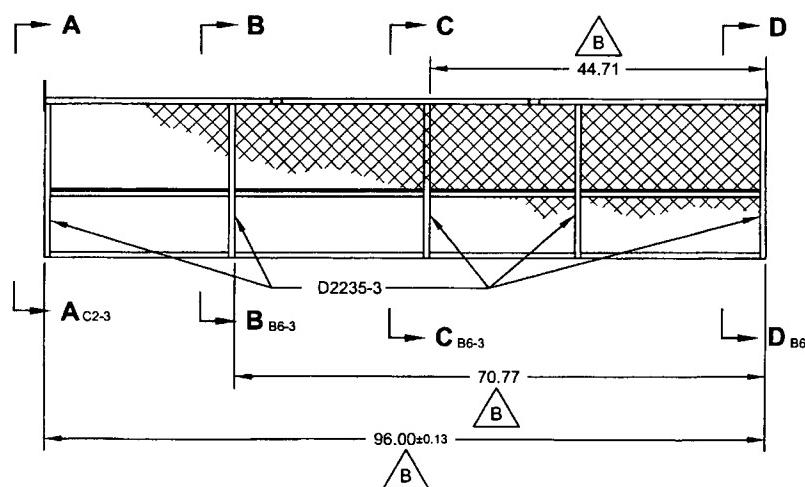
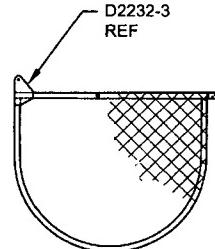
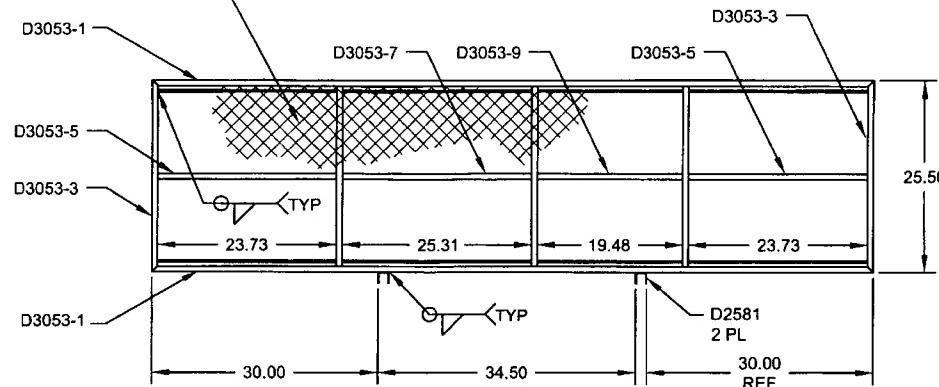
B	FRAME MATERIAL WAS 0.060 WALL. MESH MATERIAL UPDATED. DRAWING MOVED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS.	AJS	08.07.02
A	NEW ISSUE	RF	01.11.01
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3053	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (212)	
DATE	08.07.02	NTS	

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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

SKIN INSIDE SURFACE OF
BASKET WITH MESH. TACK
WELD EACH END OF STRAND
TO FRAME



**D3053-042 BASKET BASE ASSEMBLY SHOWN
(D3053-041 BASKET BASE ASSEMBLY OPPOSITE)**

REFERENCE ONLY

09-07-06

RELEASED

08-28-01 JAP

DESIGN	RF	DART AEROSPACE LTD
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		REV. B
APPROVED		D3053 SHEET 2 OF 3
DE APPR.		TITLE
DATE	08.07.02	SCALE
		BASKET BASE ASSEMBLY (212) NTS

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8 7 6 5 4 3 2 1

